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Hawkesbury, ON
K6A 1K7
Canada

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D350-636-023
Job Sheet 194171



Part No: D350-636-023

Job Qty: 1 pcs

Part Name: AS350/355 - Skidtubes - Standard w/ Heavy-Duty Wearplates - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/26/19

Job Tracking No:

Due Date: 4/30/19

Created By: Shannon Hadley

Type: Stock

Description:

Note: D4168-051 REV.C, IIN-D350-636 REV.K IPP REV.A 18.11.29 NEW ISSUE DD VERF.JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Skidtubes - 1	1 pcs	4/30/19		0.00	5.25	Skidtubes - 1 - B4B			BE
							Skidtubes - 2 - B4B			
							Skidtubes - 3 - B4B			
							Skidtubes - 4 - B4B			
							Skidtubes - 5 - B4B			
							Skidtubes - 6 - B4B			
							Skidtubes - 7 - B4B			
120	QC 10	1 pcs	4/30/19		0.00	0.00	QC 10 - 10		DAS 24 9-89	MAY 03 2019
							QC 10 - 18			
							QC 10 - 24			
							QC 10 - 43			
							QC 10 - 50			
							QC 10 - 58			
							QC 10 - 9			
130	QC 5	1 pcs	4/30/19		0.00	0.00	QC 5 - 10		DAS 68 9-89	MAY 03 2019
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			

Plex 4/26/19 8:58 AM Dart.Hadley.Shanno

140 Handfinish - 1-1 Chemical-
B4B

1
pcs

4/30/19

0.00 0.99

Handfinish - 1 - 1 - B4B

Handfinish - 1 - 2 - B4B

Handfinish - 1 - 3 - B4B

Handfinish - 1 - 4 - B4B

Handfinish - 1 - 5 - B4B

Handfinish - 1 - 6 - B4B

Handfinish - 1 - 7 - B4B

Handfinish - 1 - 8 - B4B

Handfinish - 1 - 9 - B4B

Handfinish - 1 - 10 -
B4B

D.R 19/05/06

Handfinish - 1 - 11 -
B4B

Handfinish - 1 - 12 -
B4B

Handfinish - 1 - 13 -
B4B

Handfinish - 1 - 14 -
B4B

Handfinish - 1 - 15 -
B4B

Handfinish - 1 - 16 -
B4B

Handfinish - 1 - 17 -
B4B

Handfinish - 1 - 18 -
B4B

Handfinish - 1 - 19 -
B4B

Handfinish - 1 - 20 -
B4B

Handfinish - 1 - 21 -
B4B

Handfinish - 1 - 22 -
B4B

150 QC 7

1
pcs

4/30/19

0.00 0.00

QC 7 - 10

QC 7 - 13

QC 7 - 14

QC 7 - 15

QC 7 - 17

QC 7 - 18

QC 7 - 19

QC 7 - 2

QC 7 - 28

QC 7 - 3

QC 7 - 30

QC 7 - 34

QC 7 - 36

QC 7 - 37

QC 7 - 41

QC 7 - 47

QC 7 - 48

QC 7 - 51

QC 7 - 58

QC 7 - 59

QC 7 - 60

QC 7 - 9

QC 7 - 68

QC 7 - 50

QC 7 - 67

QC 7 - 40

mbn

160 Skidtubes - 2 - B4B	1 pcs	4/30/19	0.00 5.25	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	<i>Mon</i>
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	<i>BE</i>
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 10	1 pcs	4/30/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	DAS 24 9-89
				QC 10 - 43	MAY 27 2019
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
180 QC 5	1 pcs	4/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS 24 9-89
				QC 5 - 24	MAY 27 2019
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	4/30/19	0.00 0.99	QC 5 - 30	
				QC 5 - 40	
				Handfinish - 2 - 1 - B4B	<i>25</i>
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
200 Spray Paint - 2 - B4B	1 pcs	4/30/19	0.00 0.91	Handfinish - 2 - 4 - B4B	
				Spray Paint - 1 - B4B	<i>AL19-6-2</i>
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
				Spray Paint - MJ1 - B4B	
				Spray Paint - MJ2 - B4B	
				Spray Paint - MJ3 - B4B	
210 QC 14	1 pcs	4/30/19	0.00 0.00	Spray Paint - MJ4 - B4B	
				QC 14 - 15	<i>AL19-6-5</i>
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	4/30/19	0.00 0.99	QC 14 - 19	
				Handfinish - 4 - 1 - B4B	<i>AL19-6-20</i>
				Handfinish - 4 - 10 -	

**DAS
15
9-89**

B4B	
Handfinish - 4 - 11 - B4B	
Handfinish - 4 - 12 - B4B	
Handfinish - 4 - 13 - B4B	
Handfinish - 4 - 14 - B4B	
Handfinish - 4 - 15 - B4B	
Handfinish - 4 - 2 - B4B	
Handfinish - 4 - 3 - B4B	
Handfinish - 4 - 4 - B4B	
Handfinish - 4 - 5 - B4B	
Handfinish - 4 - 6 - B4B	
Handfinish - 4 - 7 - B4B	
Handfinish - 4 - 8 - B4B	
Handfinish - 4 - 9 - B4B	

240 QC 5 1 4/30/19 0.00 0.00

QC 5 - 10	
QC 5 - 12	
QC 5 - 17	
QC 5 - 18	
QC 5 - 19	
QC 5 - 22	
QC 5 - 24	
QC 5 - 3	
QC 5 - 43	
QC 5 - 49	
QC 5 - 51	
QC 5 - 58	
QC 5 - 68	
QC 5 - 9	
QC 5 - 50	
QC 5 - 30	
QC 5 - 40	

DAS 81 DAS 68 JUN 26 2019 9-89 9-89

250 Packaging 1-1 - Pick Kit - B4B 1 4/30/19 0.00 0.00

Packaging 1 - 1 - B4B	
Packaging 1 - 2 - B4B	
Packaging 1 - 3 - B4B	
Packaging 1 - 4 - B4B	
Packaging 1 - 5 - B4B	
Packaging 1 - 6 - B4B	
Packaging 1 - 7 - B4B	
Packaging 1 - 8 - B4B	
Packaging 1 - 9 - B4B	
Packaging 1 - 10 - B4B	
Packaging 1 - 11 - B4B	
Packaging 1 - 12 - B4B	
Packaging 1 - 13 - B4B	
Packaging 1 - 14 - B4B	
Packaging 1 - 15 - B4B	
Packaging 1 - 16 - B4B	
Packaging 1 - 17 - B4B	
Packaging 1 - 18 - B4B	
Packaging 1 - 19 - B4B	
Packaging 1 - 20 - B4B	
Packaging 1 - 21 - B4B	
Packaging 1 - 22 - B4B	
Packaging 1 - 23 - B4B	
Packaging 1 - 24 - B4B	

DAS 28 9-89

260 QC 4	1 pcs	4/30/19	0.00 0.00	Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
				QC 4 - 28	DAS 1
				QC 4 - 58	75
				QC 4 - 69	9-89
				QC 4 - 9	
				QC 4 - 46	JUL 11 2019
				QC 4 - 68	
270 Packaging 3-1 - Stock - B4B	1 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	75
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	JUL 11 2019
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	4/30/19	0.00 0.00	DC - 1 - B4B	DAS 21
				DC - 2 - B4B	9-89 JUL 11 2019
280 QC 21 - FG	1 pcs	4/30/19	0.00 0.00	QC 21 - FG - 21	DAS 21
				QC 21 - FG - 70	9-89 JUL 11 2019
				QC 21 - FG - 53	9-89

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D4168-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
 then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER
 POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168
 sheet 4 (D4168-5 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side 4- Locate
 DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section DE-DE. Open to 0.500" using hole saw.
 VERIFY AND RECORD FWD BEND ANGLE. 5- Drill tow ring hole using DT9616 detail "DA" 6- Drill most FWD wearplate
 hole using DT9678 locating off of 66.54" hole. 7- Open up holes of Detail DA to 0.297" (total of 2 holes per side) and .201"
 (total of 1 hole per side using DT9616) 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from
 bending as per QSI 004 A/R Aluminum Rod batch: 138989 9- Grind welds flush as per Dwg D4168
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - 1-Open up holes using hole saw of Detail DB and ground handling section EN-EN to 0.625" (total of 8 holes per
 side) as per dwg D4168. Open wearplate holes to size as per dwg (4 holes per sides) , section EP-EP 4-Chamfer holes of
 Detail DB, ground handling section AL-AL per dwg D4168 (welding instructions on sheet 8) 5-Deburr and blow out all
 chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI
 015, let cure for 12hrs. A/R Sikaflex-291 batch: 517430 exp. date: 03/12/2014 ***ATTN: USE I-BEAM LOCATION
 AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D4168 and D4170-1 & QSI004 (welding instructions on
 sheet) A/R Aluminum Rod batch: 139011 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling
 holes section (total of 4 places per side) as per dwg D4168, section EN-EN 12- C'bore section CG-CG. ADJUST
 TOOLING AS REQUIRED. VERF BY: _____ 13- Deburr holes, ensure tube is free of all scratches before
 sending to paint. *****
 170 - QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do
 not acid etch.
 200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349
 BATCH: 5179552 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5184740
 210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
 230 - (Assemble as per dwg) 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting
 D3488-3, wearshoes and ground handling hardware as per dwg D4168 SIKAFLEX 241 BATCH: 517834 EXP
 DATE: 14-12-2 5-Coat all exposed fasteners with "LPS Procyon" batch: M133690
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Pick Kit) If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A
 260 - QC4- 100% Inspect kits for completeness)*****ensure antiseize is on AN8C21A bolts*****
 270 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPPD350-636-023 Location
 :FG071
 275 - record fwd angle: 89.9° Photocopy blue file and type labels per PPP D350-636-023 CHG 001
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skidtubes - 1
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B
D3873-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1149C0332R	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1149C0363R	Washer	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1149C0832R	Washer	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B

Container
010186
5166439
5150291
5176881
5166521
5167517
5186091-1
F1137071-1-2
5176396
5167090
x 518187
5179442
5184142
x 5184142
5175770
x 5191509
5175928
5180790
5099569
5181777
5167203-1
5158070
5135100
5076012-2
5083559
5162124
5160967
5159549
5167203
5166718

010748

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-LH	1	6	0
	D2744	1	16	0
160-Skidtubes - 2 - B4B	D2739	1	8	0
	D2743	8	135	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	4	1,681	0
	AN3C34A	1	12	0
	AN3C36A	4	351	0
	AN3C6A	4	317	0
	AN6C44A	4	132	0
	AN8C35A	1	62	0
	D2745	8	168	0
	D3488-3	1	3	0
	D3631-1	8	197	0
	D3873-1	7	76	0
	D4154-041	1	5	0
	D4170-1	4	38	0
	D4171-1	1	8	0
	MS21043-3	5	1,018	0
	MS21043-6	4	154	0
	MS21083C8	1	210	0
	NAS1149C0332R	4	5,640	0
	NAS1149C0363R	9	437	0
	NAS1149C0832R	1	340	0
	NAS1515H3L	4	358	0
250-Packaging 1-1 - Pick Kit - B4B	AN3C37A	1	52	0
	AN8C21A	2	85	0
	D2741	1	63	0
	MS21083C8	2	210	0
	NAS1149D0863J	2	465	0

Part Specifications

Specifications could not be found.

Plex 4/26/19 8:58 AM Dart, Hadley, Shannon

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X					D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X				D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X			D4168-044	350 SKIDTUBE ASSEMBLY, RH
				X		D4168-051	350 SKIDTUBE ASSEMBLY, LH
					X	D4168-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG ASSEMBLY
8	8					D3492-043	PLUG ASSEMBLY
		8	8			D3492-045	PLUG ASSEMBLY
8	8	8	8	8	8	D3631-1	WASHER
7	7	7	7	7	7	D3873-1	BUSHING
1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1						D4168-1	SKIDTUBE WELDMENT, LH
	1					D4168-2	SKIDTUBE WELDMENT, RH
		1				D4168-3	SKIDTUBE WELDMENT, LH
			1			D4168-4	SKIDTUBE WELDMENT, RH
				1		D4168-5	SKIDTUBE WELDMENT, LH
					1	D4168-6	SKIDTUBE WELDMENT, RH
4	4	4	4	4	4	D4170-1	SPACER
1	1	1	1	1	1	D4171-1	BUSHING
4	4	4	4	4	4	ALS4-1032-225	INSERT
1	1	1	1	1	1	AN3C34A	BOLT
4	4	4	4	4	4	AN3C36A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
5	5	5	5	5	5	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
4	4	4	4	4	4	NAS1149C0332R	WASHER
9	9	9	9	9	9	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.3
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 lbs
D4168-051/-052 = 31.9 lbs
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER

NO. 193528 MJS
19-04-16

C	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D4168-5/-6 (ZN B5-1, SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11, D2-12, D2-13, D2-14); ADDED NOTES 13, 14 (ZN C4-1); NAS1149C0363R WAS AN960C10 (ZN A5-1, C6-11, C7-11, D8-11, C6-12, C7-12, D8-12, C6-13, C7-13, D8-13, C6-14, C7-14, D8-14); NAS1149C0332R WAS AN960C10L (ZN B1-11, B1-12, B1-13, B1-14); NAS1149C0832R WAS AN960C816L (ZN C1-11, C1-12, C1-13, C1-14)	ZF	18.03.01
B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 1 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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2019 OCT 19
ED 19-03

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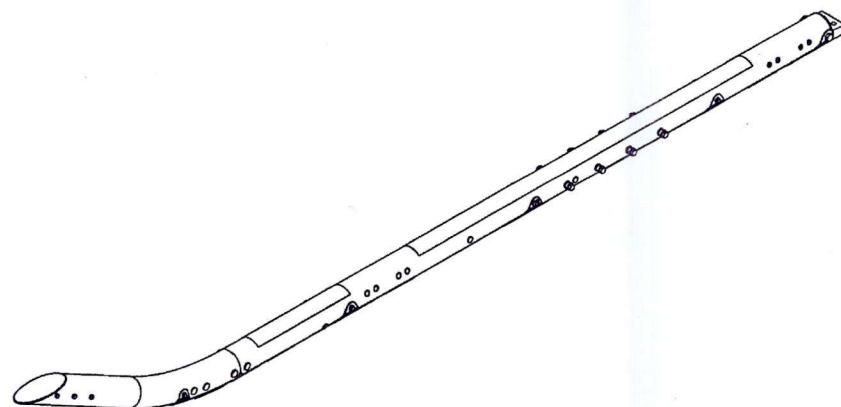
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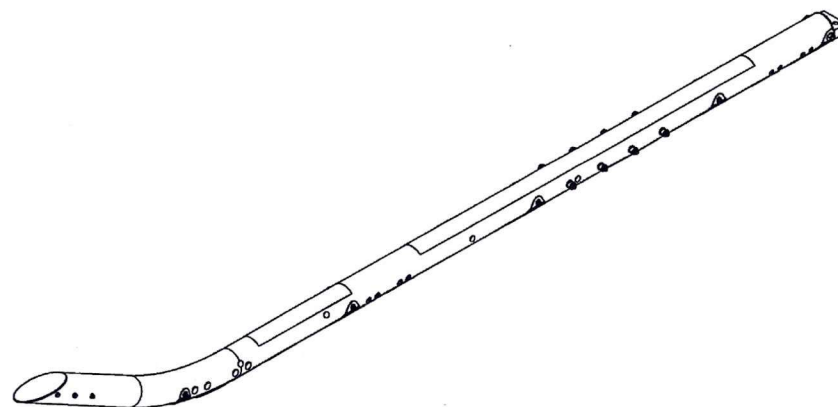
C

B

A



D4168-041 350 SKIDTUBE ASSEMBLY, LH



D4168-042 350 SKIDTUBE ASSEMBLY, RH

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2018 OCT 19

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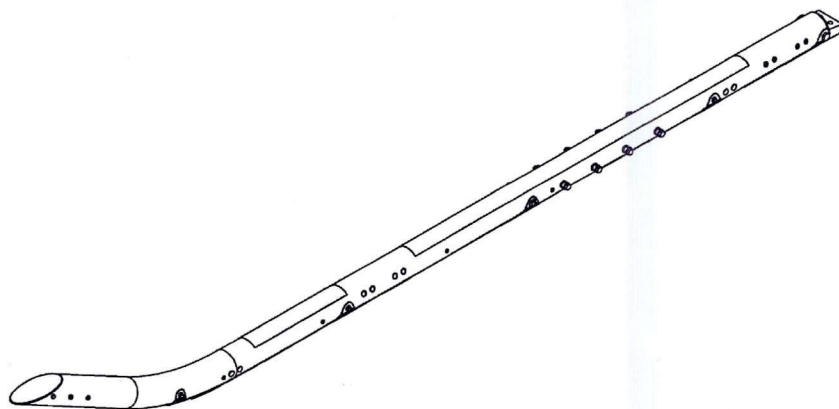
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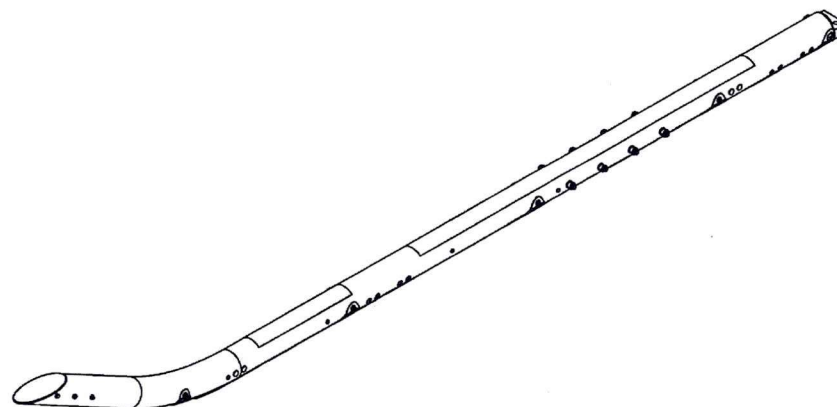
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D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH

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2018 OCT 19

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APPROVED	NO	TITLE	SCALE
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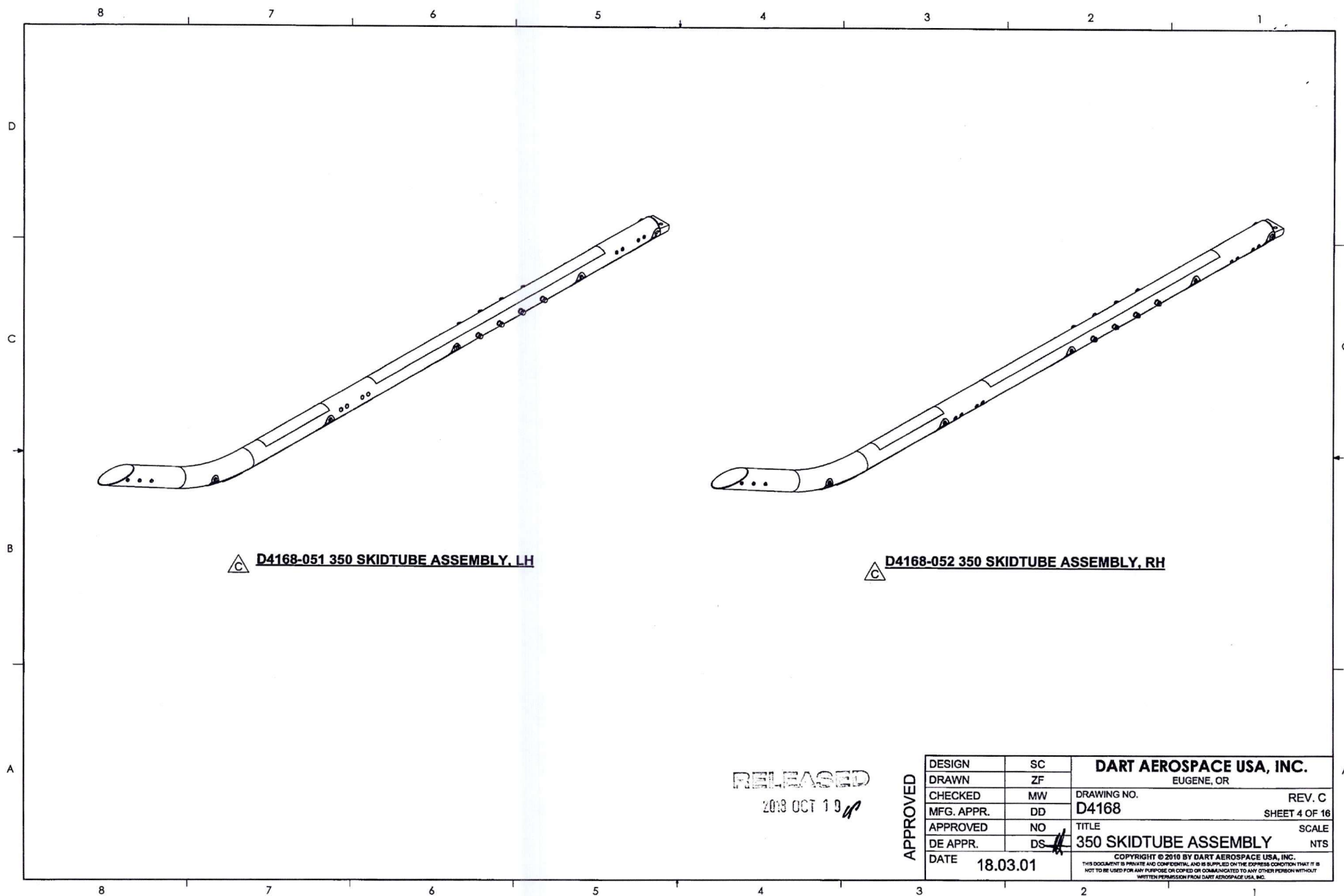
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D4168-051 350 SKIDTUBE ASSEMBLY, LH

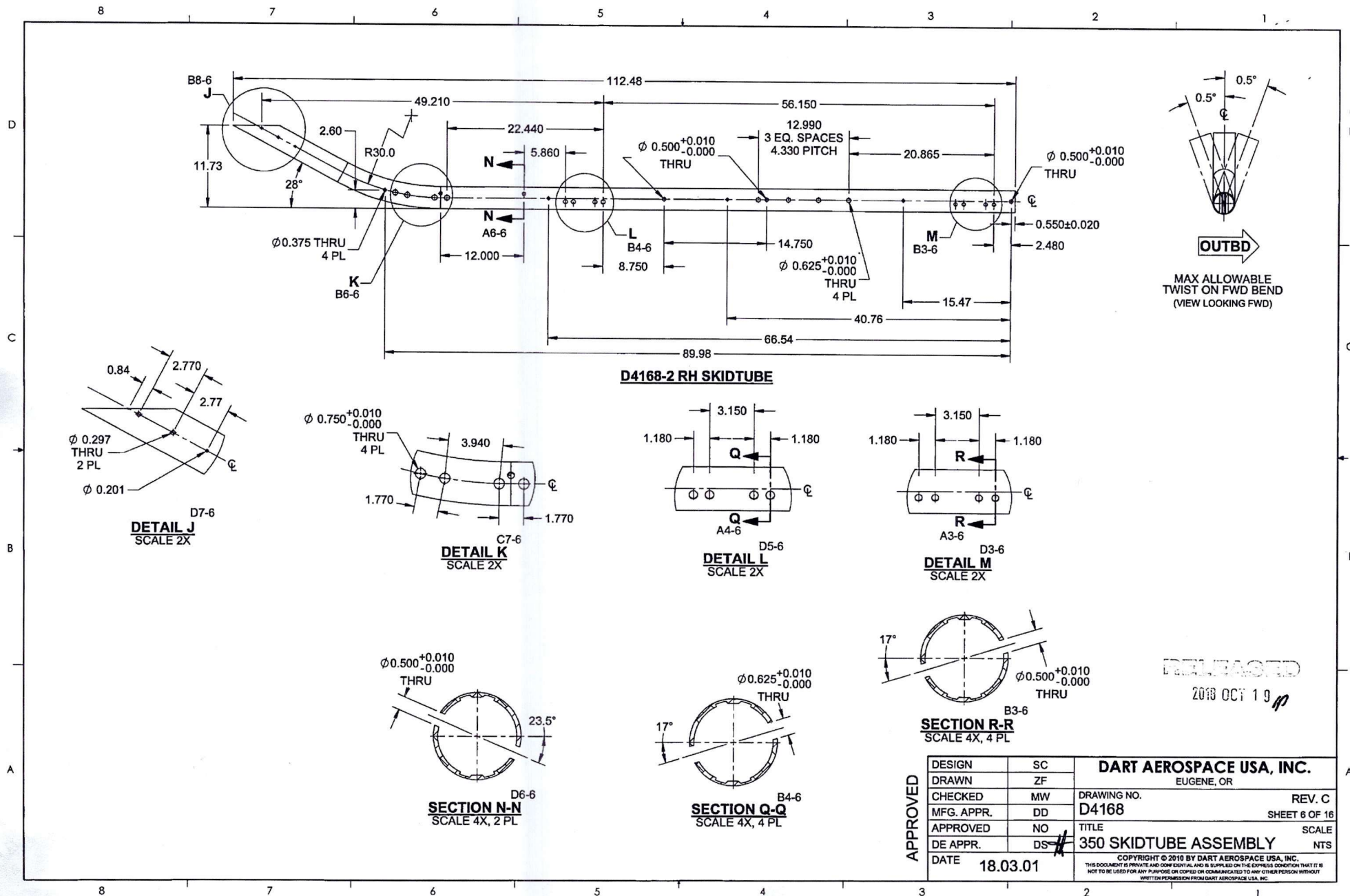
D4168-052 350 SKIDTUBE ASSEMBLY, RH

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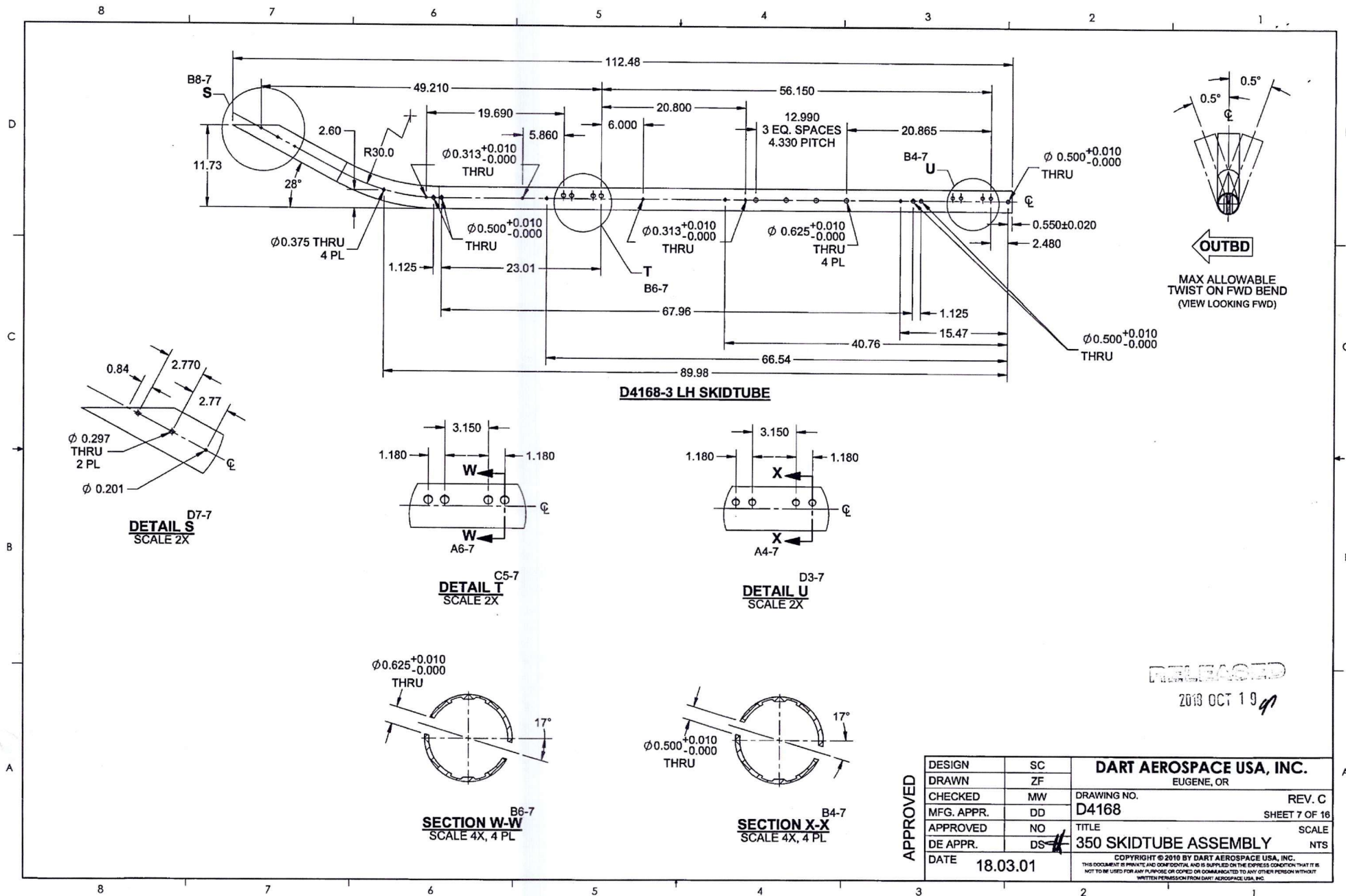
2013 OCT 10

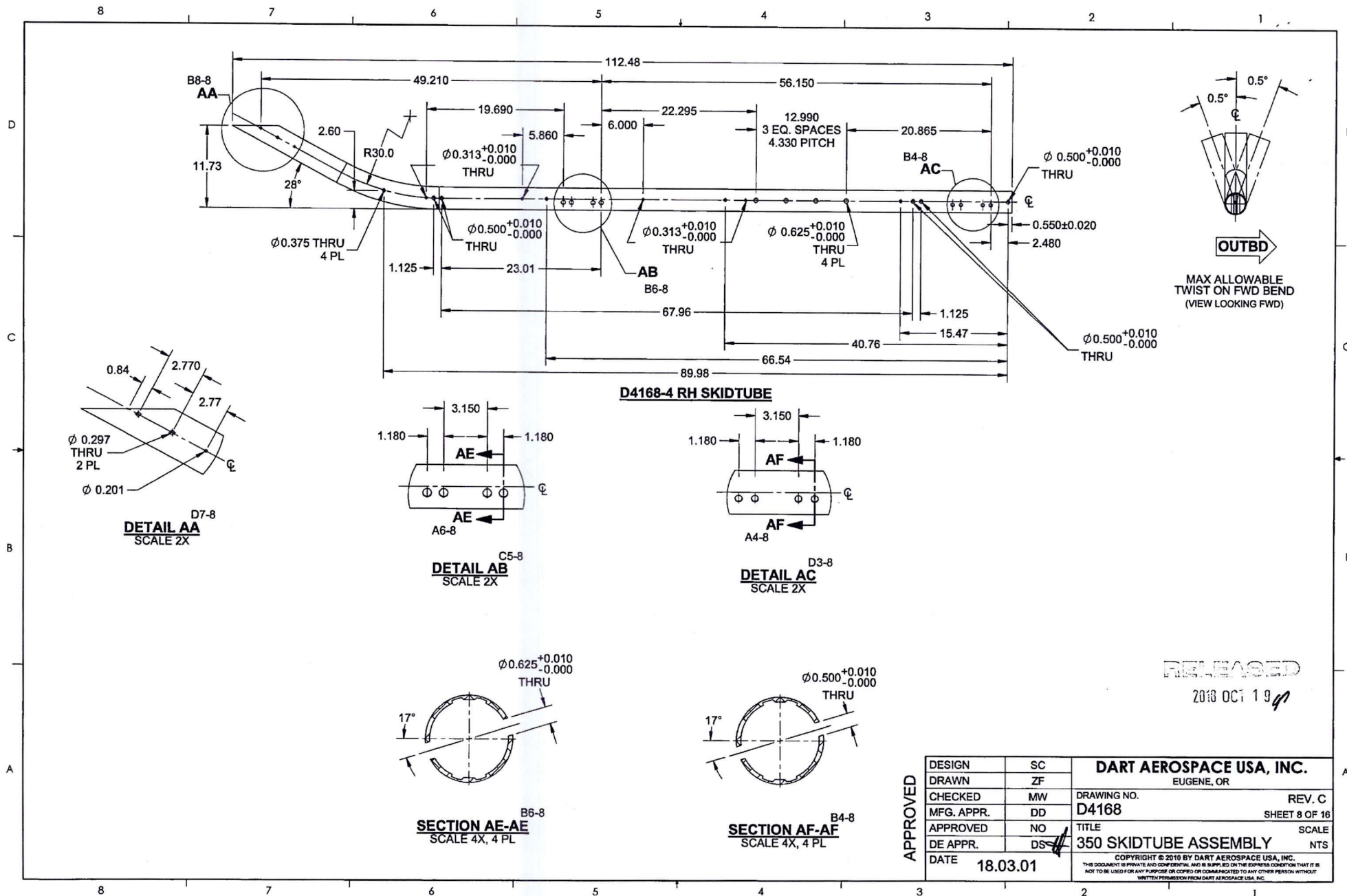
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CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 4 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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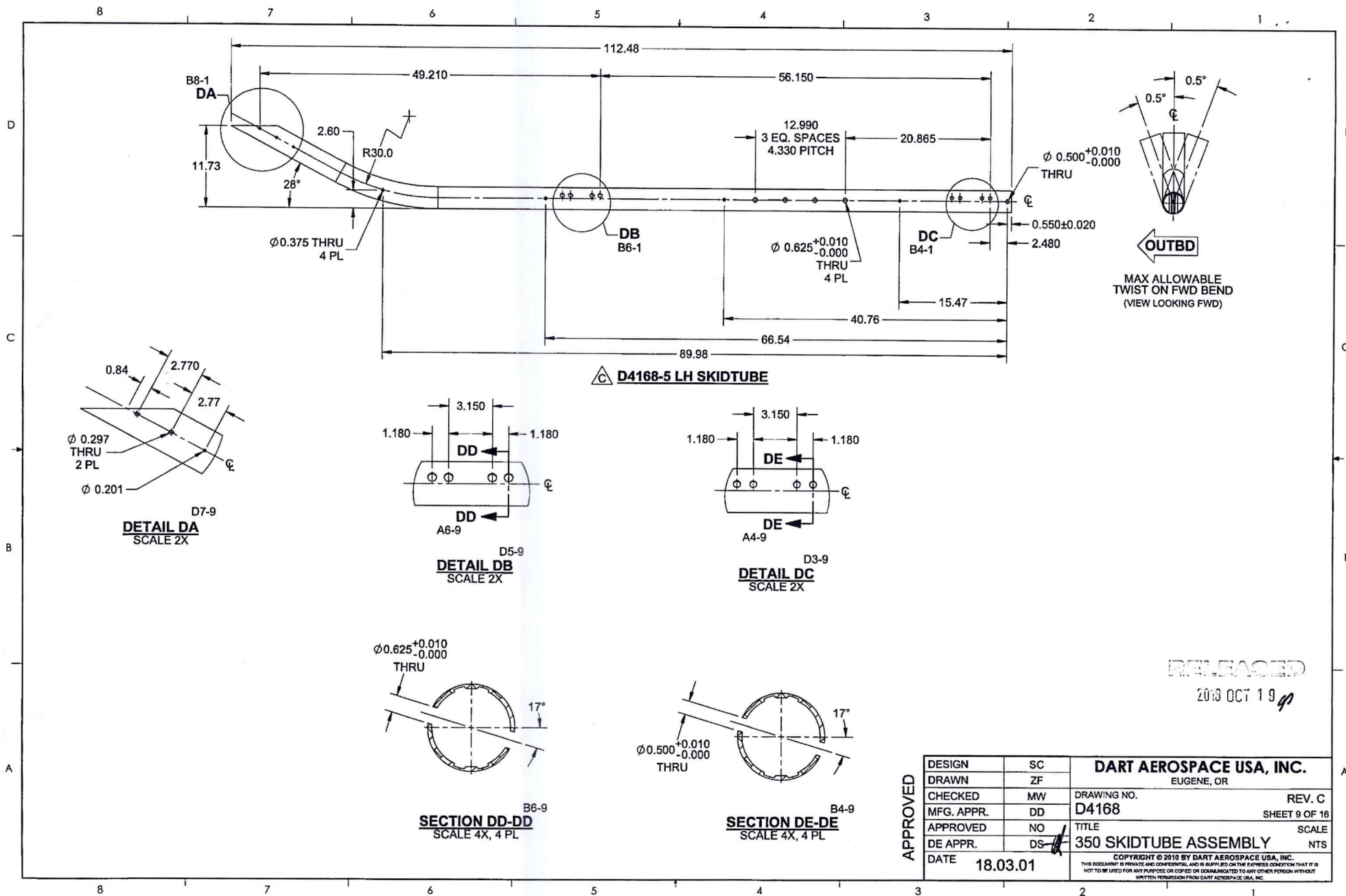
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	DRAWN	ZF		
	CHECKED	MW	DRAWING NO.	REV. C
	MFG. APPR.	DD	D4168	SHEET 6 OF 16
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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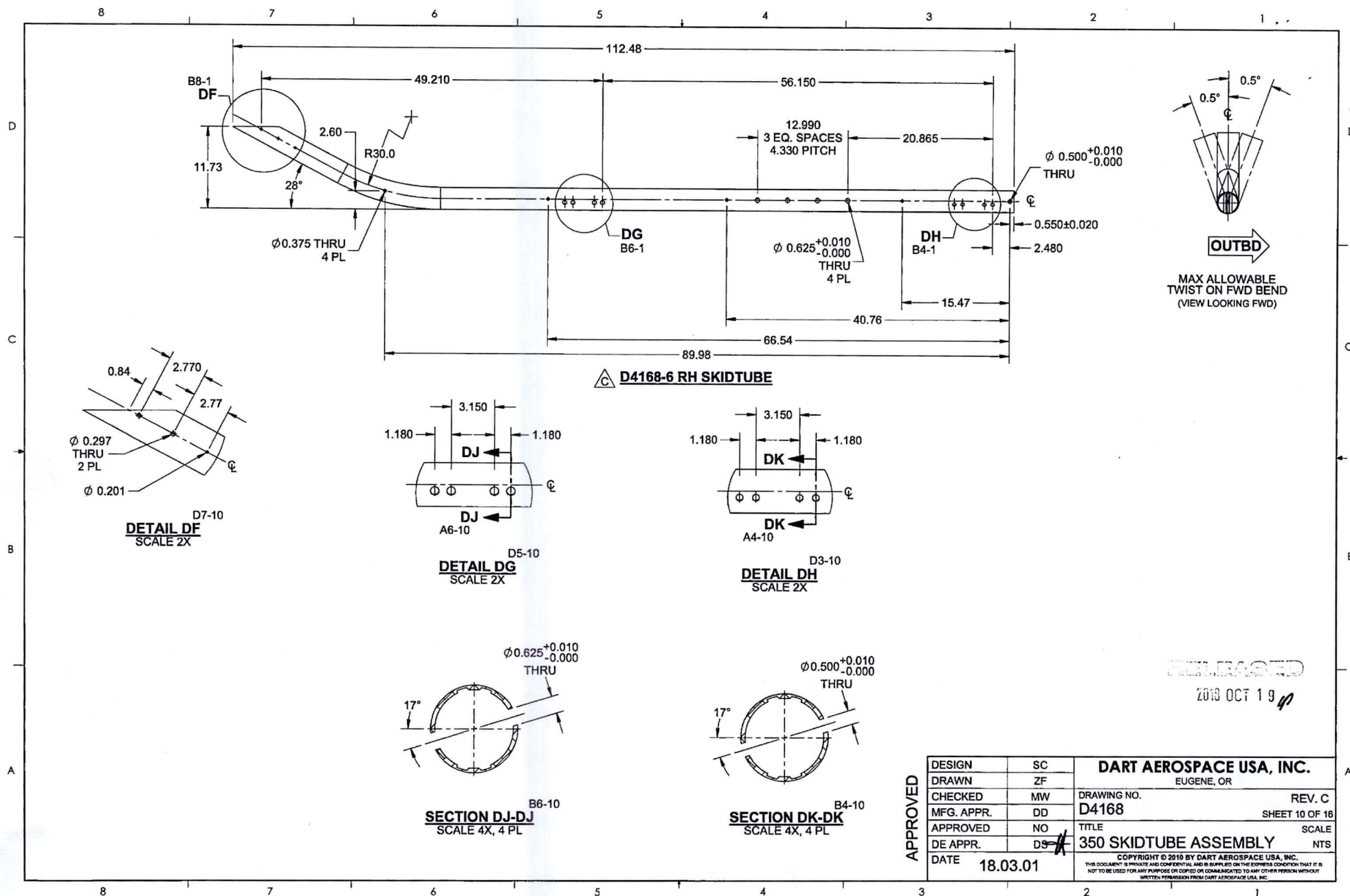
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2010 OCT 19



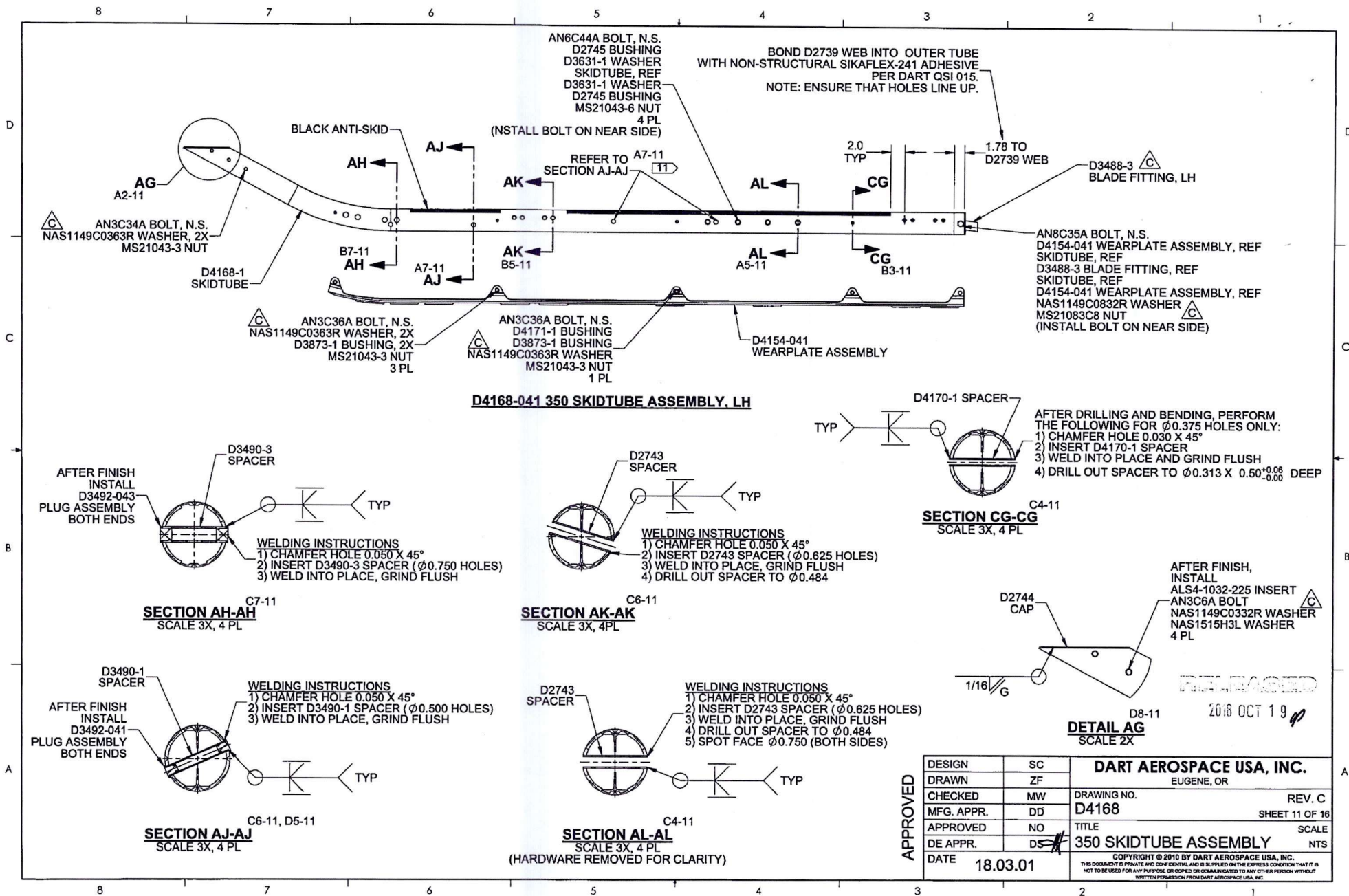
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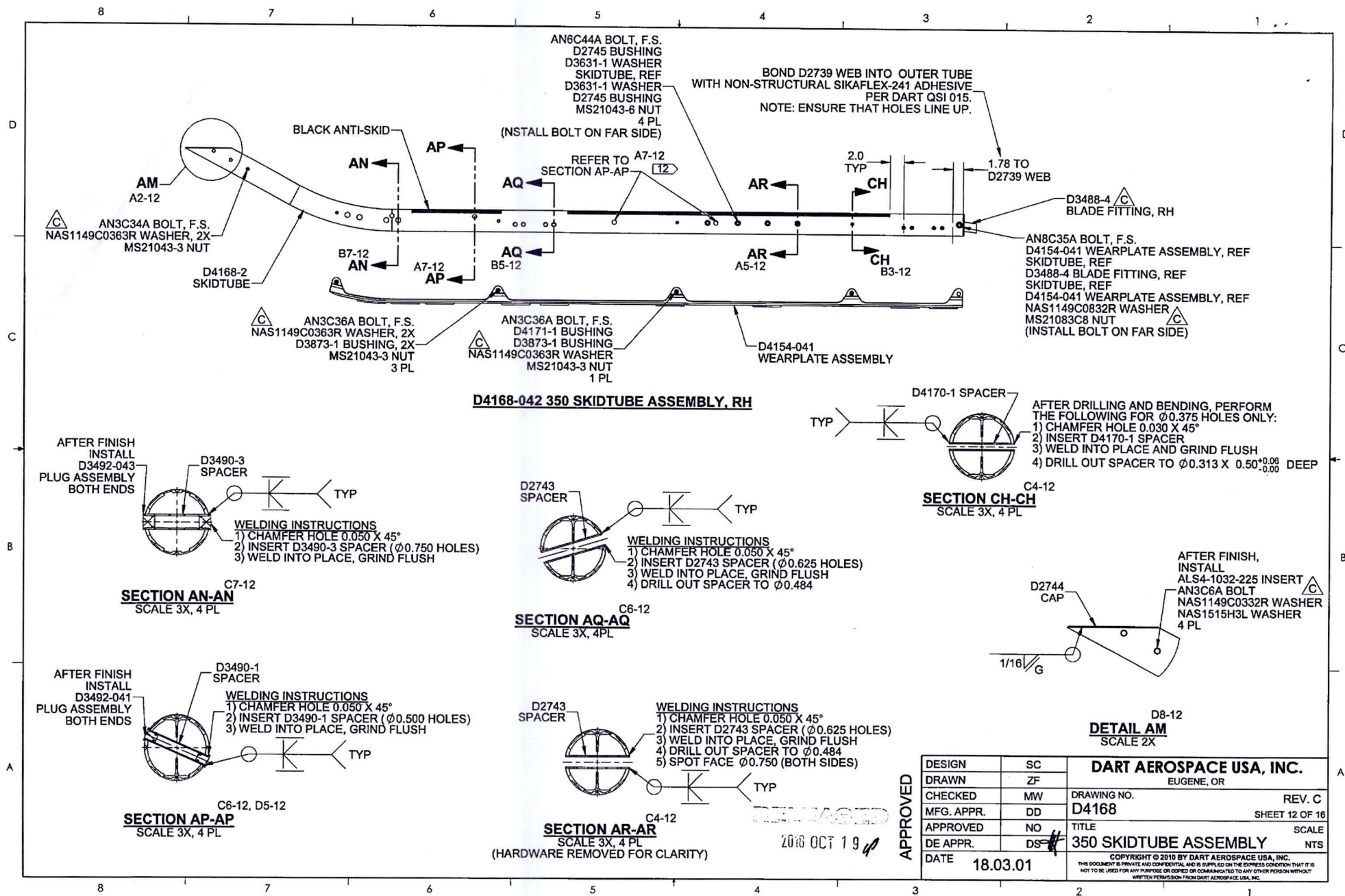
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MFG. APPR.	DD	D4168	SHEET 9 OF 16
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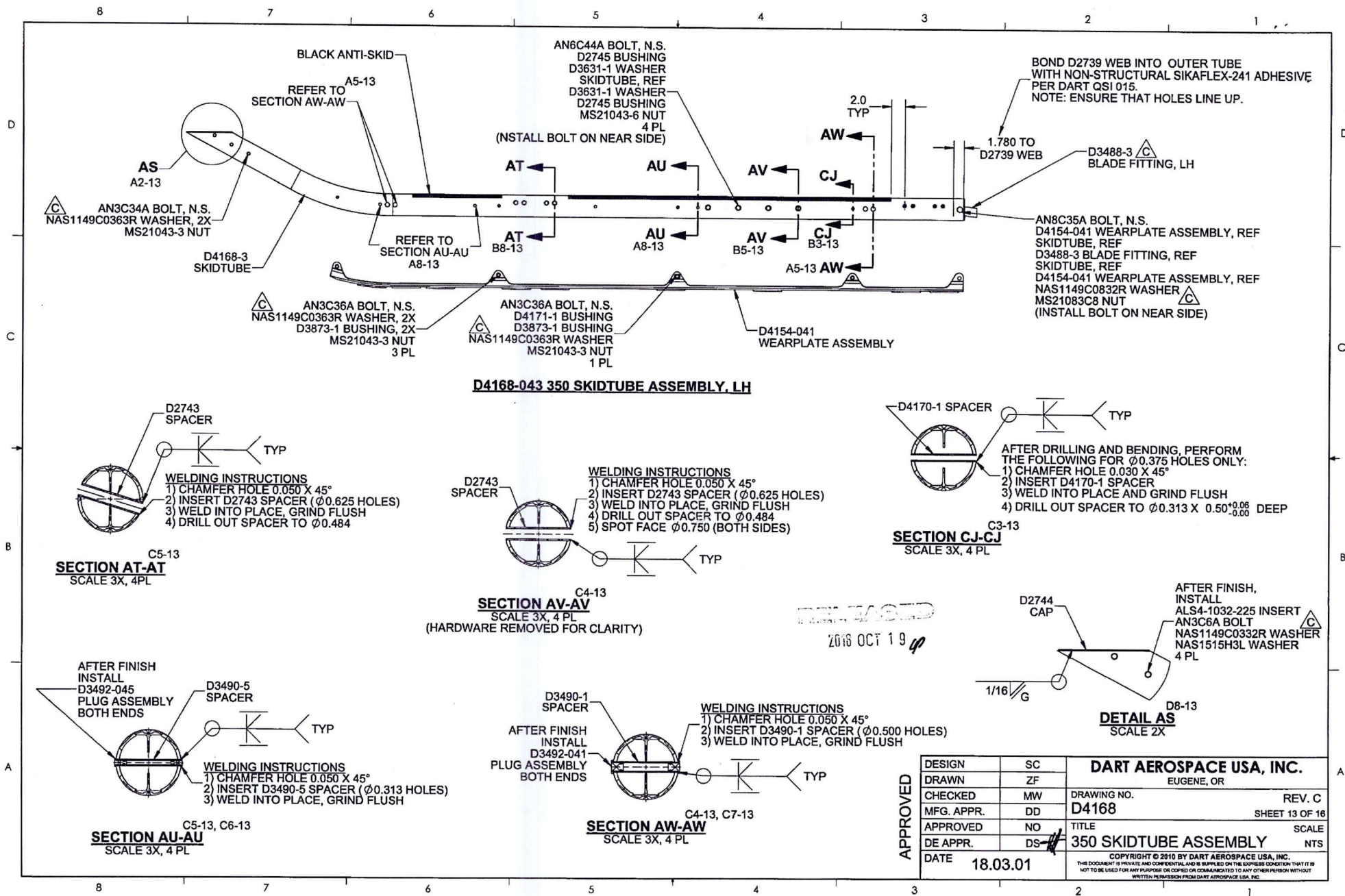


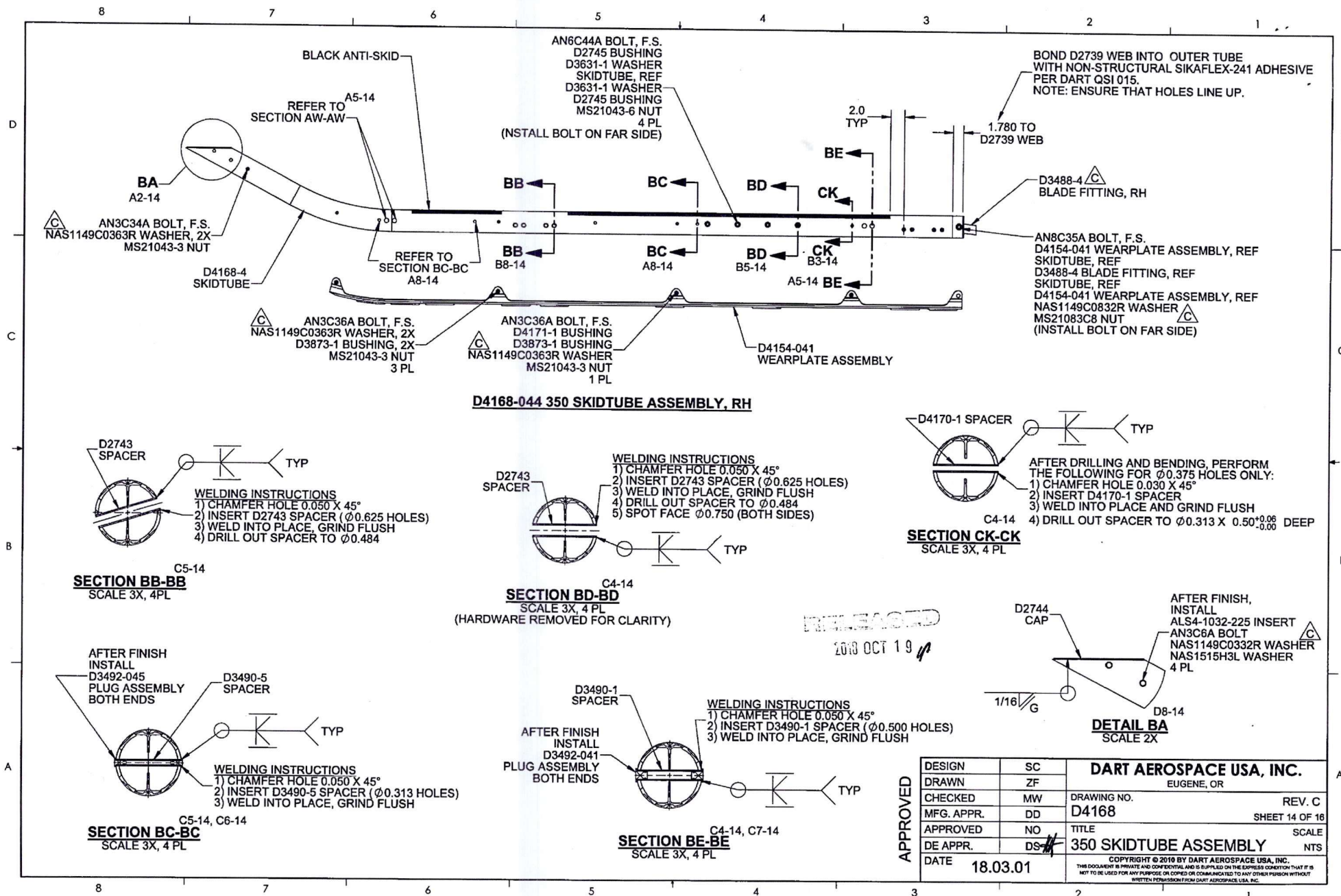
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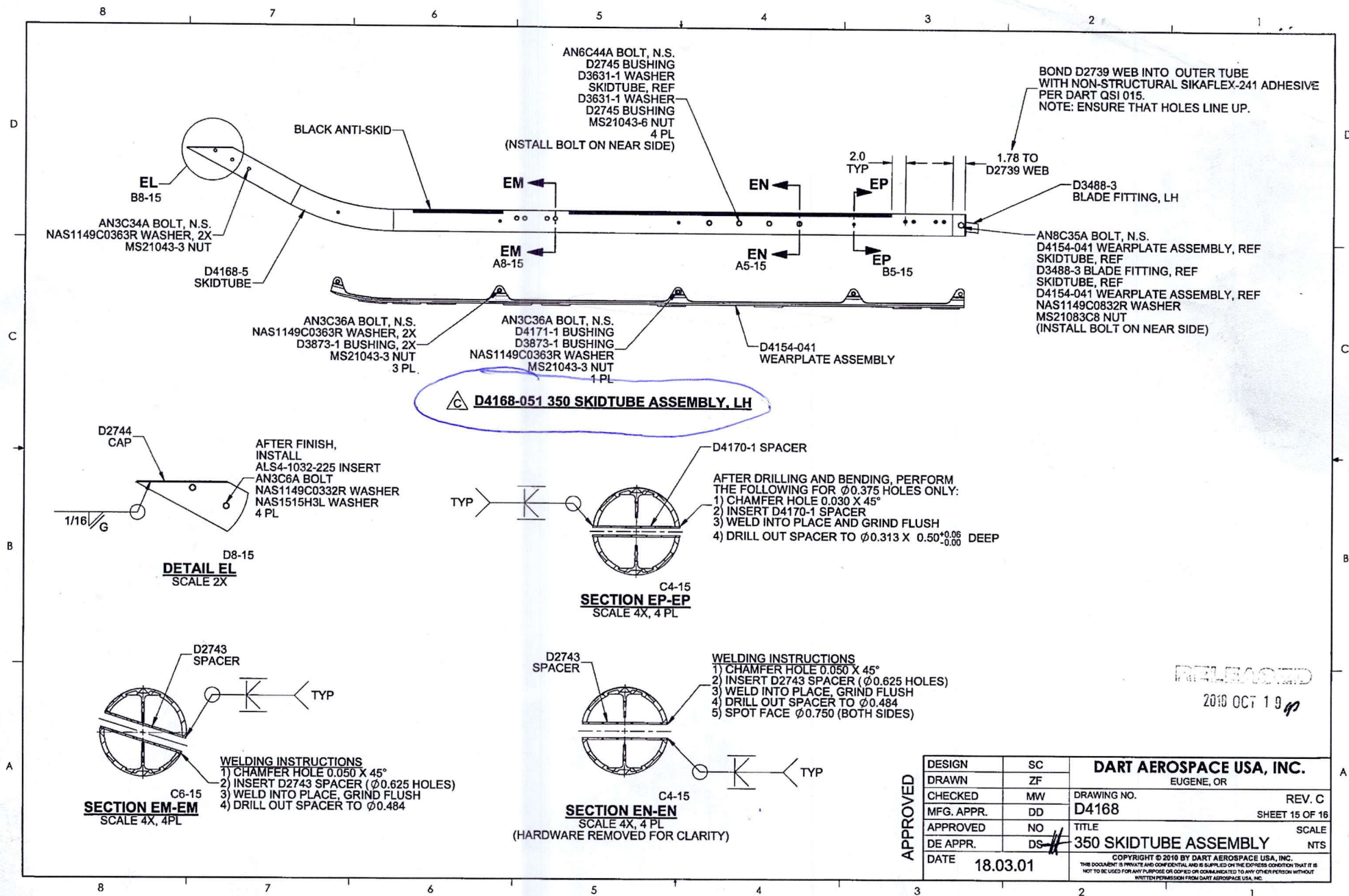
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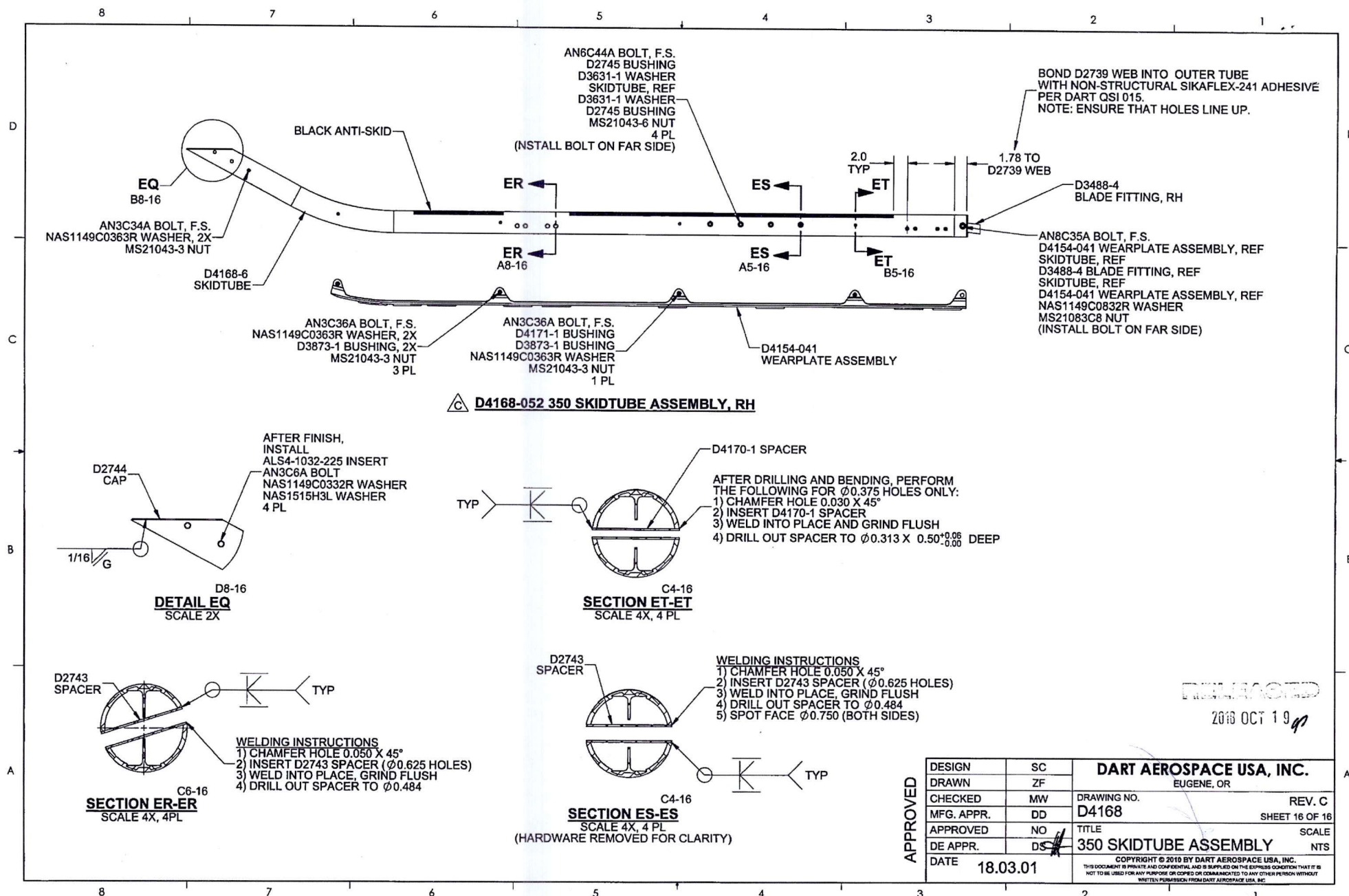






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2010 OCT 19



Entered: _____

WORK ORDER NON-CONFORMANCE

Route update only

NCR No. _____ Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
Other/Details:							

DART
AEROSPACE

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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S177147



Part: D350-636-023

Job No: 194171

Serial No/Batch: S177147

Revision: C/K

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17, TC, STC SH99-7 Issue 2, EASA S

H771471S

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCUISE/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCUISE/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149CO863J	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

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Revision: K
Date: 18.04.04

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS

² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS

³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

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Revision: **K**

Date: 18.04.04

Change Record

PAGE 1 OF 1

Part Number: D350-636-023/-024

Description: SKIDTUBE INSTALLATION LH/RH, STD COMPATIBLE W/TRAINING WEARPLATI

[illegible]